Qty:

1 Um:

Each

: SADDLE KIT FOR D206-642-511

: K642 511

· N/A

: N/A

: N/A

: NIA

: 6/22/2007

Date:

Thursday, 6/21/2007 1:52:33 PM

User:

Kim Johnston

## **Process Sheet**

**Drawing Name** 

Part Number

Material

**Due Date** 

**Drawing Number** 

Project Number

**Drawing Revision** 

Customer

Job Number **Estimate Number** : 12893

: CU-DAR001 Dart Helicopters Services

: 33097

P.O. Number

ALL

S.O. No. : NA 6/21/2007

This Issue Prsht Rev. First Issue

NIA

: LANDING GEAR Type

FILE : Previous Run

Written By Checked & Approved By

Comment

**Additional Product** 

new issue **0**7.06.05

Seq. #:

Job Number:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP K642-511

CHG003

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

D2652 3.0

Bushing



Comment: Qtv.:

16,0000 Each(s) Total:

Pick:

Qty Part Number

16 D2652

Description

Bushing

4.0

D2712



10.0000 Each(s)/Unit

16.0000 Each(s)/Unit

Total:

10.0000 Each(s)

Comment: Qty.: Pick:

**Qty Part Number** 

10 D2712

Description

Set Screw

5.0

D29321



Comment: Qty.: 1.0000 Each(s)/Unit

Total:

1.0000 Each(s)

Pick:

**Qty Part Number** 1 D2932-1

W/O:		WORK ORDE	R CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B Verification Ap		Anneval	Annroyal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Thursday, 6/21/2007 1:52:33 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: SADDLE KIT FOR D206-642-511 Customer: CU-DAR001 Dart Helicopters Services Part Number: K642 511 Job Number: 33097 Job Number: Description: Seq. #: Machine Or Operation: 206 Saddle Left 6.0 D29331 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: **Qty Part Number** Batch Saddle 1 D2933-1 7.0 D2934 Saddle Spacer 2.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: **Qty Part Number** Description Saddle Spacer 2 D2934 D2935 8.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Description Qty Part Number Saddle Spacer 2 D2935 9.0 D29381 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Saddle 1 D2938-1 10.0 D29391 1.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Pick: **Qty Part Number** Description 1 D2939-1 Saddle D33963 11.0 Inventory Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: 2/6/259 **Qty Part Number** Description 2 D3396-3

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W/O:			WC	ORK ORDER CHANGES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:	·		WORK ORDE	ER NON-CONFORMANC	E (NCF	₹)			
		Description of NC		Corrective Action Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
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Thursday, 6/21/2007 1:52:33 PM Date:\* User: Kim Johnston **Process Sheet** Drawing Name: SADDLE KIT FOR D206-642-511 Customer: CU-DAR001 Dart Helicopters Services Job Number: 33097 Part Number: K642 511 Job Number: Description: Seq. #: Machine Or Operation: Tow Ring D3407043 12.0 Total: 1.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Pick: Qty Part Number Description Batch 1 D3407-043 Tow Ring D34561 13.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Batch **Qty Part Number** Description 1 D3456-1 Washer D34571 14.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: **Qty Part Number** Description 2 D3457-1 Washer AN3C35A 15.0 Comment: Qty.: 3.0000 Each(s) 3.0000 Each(s)/Unit Total: Pick: Qty Part Number Description Bolt 3 AN3C35A 16.0 AN3C36A Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s) Pick: Description Batch Qty Part Number 9 AN3C36A 17.0 AN3C41A Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s) 7/6/2150 Pick: Batch **Qty Part Number** Description 8 AN3C41A Bolt

Dart Ae	rospace	e Ltd							
N/O:			WC	RK ORDER CHANGES	3				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	<b>A</b> :	_ Date: _	
					QA: N/	C Closed	d:	_ Date: _	
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DATE	STEP	Description of NC Section A			tion B Sign &		ation	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng	Date	Secu	UII C		QC IIIspector
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Thursday, 6/21/2007 1:52:33 PM Date:\* Kim Johnston User: **Process Sheet** Drawing Name: SADDLE KIT FOR D206-642-511 Customer: CU-DAR001 Dart Helicopters Services Job Number: 33097 Part Number: K642 511 Job Number: Description: Seq. #: Machine Or Operation: Bolt 18.0 AN4C6A Comment: Qty.: 12.0000 Each(s) 12.0000 Each(s)/Unit 13 Pick: **Qty Part Number** Description 12 AN4C6A 19.0 AN5C11A Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: Qty Part Number Description 8 AN5C11A AN5C12A 20.0 Comment: Qty.: Total: 4.0000 Each(s) 4.0000 Each(s)/Unit Pick: **Qty Part Number** Description Bolt 4 AN5C12A AN5C13A 21.0 Comment: Qty.: 4.0000 Each(s) 4.0000 Each(s)/Unit Total: Pick: **Qty Part Number** Description Bolt AN5C13A 22.0 AN5C15A 1.0000 Each(s)/Unit Comment: Qty.: Total: 1.0000 Each(s) Pick: **Qty Part Number** Batch 1 AN5C15A AN5C32A 23.0 Comment: Qty.: 2.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: 2/6/21 59 Qty Part Number Description 2 AN5C32A Bolt

	WORK ORDER	CHANGES				
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		Description of NC		Corrective Action Section B		Verification	Ammount	Ammanal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Thursday, 6/21/2007 1:52:33 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: SADDLE KIT FOR D206-642-511 Customer: CU-DAR001 Dart Helicopters Services Job Number: 33097 Part Number: K642 511 Job Number: Description: Seq. #: Machine Or Operation: 24.0 AN5C34A 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Comment: Qty.: Pick: Qty Part Number 2 AN5C34A 25.0 AN5C35A Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number 1 AN5C35A AN960C10L 26.0 Comment: Qty.: 24.0000 Each(s) 24.0000 Each(s)/Unit Total: Pick: Description **Qty Part Number** 24 AN960C10L Washer \_\_\_ WASHER 27.0 AN960C416L 24.0000 Each(s)/Unit Total: 24.0000 Each(s) Comment: Qty.: Pick: Description Qty Part Number Washer \_\_\_\_\_\_\_ 24 AN960C416L WASHER 28.0 AN960C516L Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: 7/6/21 59 M103344 V **Qty Part Number** Description Washer 8 AN960C516L

<b>W</b> /O:	WORK ORDER CHANGES			
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			QA: N/C Closed:	Date:

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Thursday, 6/21/2007 1:52:34 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: SADDLE KIT FOR D206-642-511 Customer: CU-DAR001 Dart Helicopters Services Job Number: 33097 Part Number: K642 511 Job Number: Description: Seq. #: Machine Or Operation: Nut 29.0 MS210433 20.0000 Each(s) Total: Comment: Qty.: 20.0000 Each(s)/Unit Pick: **Qty Part Number** 20 MS21043-3 Nut 30.0 MS210434 Comment: Qty.: Total: 13.0000 Each(s) 13.0000 Each(s)/Unit Pick: **Qty Part Number** Description 13 MS21043-4 31.0 MS210435 Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Qty Part Number Description 4 MS21043-5Nut\_ WASHER 32.0 NAS1515H3L 24.0000 Each(s) Comment: Qty.: 24.0000 Each(s)/Unit **Qty Part Number** Description 24 NAS1515H3L Washer 33.0 NAS1515H4L 24.0000 Each(s)/Unit Comment: Qty.: Total: 24.0000 Each(s) Pick: **Qty Part Number** Description 24 NAS1515H4L Washer NAS1515H5 34.0 Comment: Qty.: 16.0000 Each(s) 16.0000 Each(s)/Unit Total: Pick: **Qty Part Number** Description Batch

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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
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Thursday, 6/21/2007 1:52:34 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: SADDLE KIT FOR D206-642-511 Customer: CU-DAR001 Dart Helicopters Services Part Number: K642 511 Job Number: 33097 Job Number: Description: Seq. #: Machine Or Operation: 16 NAS1515H5 Washer NAS1515H5L WASHER 35.0 8.0000 Each(s) Comment: Qty.: 8.0000 Each(s)/Unit Total: Pick: Qty Part Number Description NAS1515H5L Washer 8 QC4 Comment: INSPECT TS FOR COMPLETENESS PACKAGING RESOURCE #1 37.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP K642-511, FINAL INSPECTION/W/O RELEASE QC21 38.0 Comment: FINAL INSPECTION/W/O RELEASE U St. 56.22 Job Completion

W/O:		WOR	K ORDER CHANGES	•			•	
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